

Date: Monday, 2/11/2008 2:14:47 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR 212/412
Job Number : 37364	
Estimate Number : 10887	
P.O. Number :	Part Number : D412711011
This Issue : 2/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 36195	Material :
Written By : <u> </u>	Due Date : 3/21/2008 Qty: 1 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: A 04.09.29 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 5673 to Eagle Copters

C. 2/8/02/12

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0	D412711041	Vertical Ref. Door Assy
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7/64443

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

4.0	D41271101	Replacement Bubble Window
-----	-----------	---------------------------



LT 08-00122Z



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

5.0	D412711111	Wiring Harness, 212/412
-----	------------	-------------------------



Comment: Qty.: 1.0000 Eagle(s)/Unit Total: 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

LT 08-002290.1

will shipped separately @ later date

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



W/ 43667



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412 W/ 43667

[Signature]

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

[Signature]

EAGLE

Pick: Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door LT08-000696

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number

Description Batch

1 EB212-100L / EA20469-3 Window LT 08-001222

1 EA20469-05 Rubber Strip ET 06-011664

1 EA20469-06 Aluminum Strip Deleted

1 EA20469-07 Angle W/ 43547

1 EA20469-08 Placard N/A

1 EA20469-10 Rear Rib Assy W/ 43547

1 EA20469-11 Angle W/ 43547

1 EA20469-12 Fwd Rib W/ 43547

1 EA20469-13 Window W/ 43547

1 EA20469-14 Window Retainer W/ 43547

1 EA20469-16 Armrest Assy W/ 43547

1 EA20469-17 Angle W/ 43547

1 EA20469-18 Door Inner Skin W/ 43547

1 EA20469-21 Door Cover Panel W/ 43547

2 EA20469-23 Link W/ 43547

1 EA20469-24 Rod W/ 43547

1 EA20469-25 Arm Assy W/ 43547

Material Certification / Proof of Traceability / Certificate of Conformity required

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description:

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt 07-18796

22 AN3-4A Bolt 08-001209

24 AN3-7A Bolt 07-017476

6 AN960-6L Washer 05-022623

90 AN960-10L Washer 06-018522

34 CR3242-4-2 Rivet 08-001645

135MS20426AD3-3 Rivet 07-006985

140MS20426AD4-3 Rivet 05-002460

25 MS20470AD3-3 Rivet 07-007189

90 MS20470AD4-3 Rivet 07-005056

24 MS21042L3 Nut 08-002039

2 MS21042L06 Nut 06-014775

13 MS21069L3 Nut Plate 08-001202

8 MS21069L08 Nut Plate 07-018940

1 MS21071L3 Nut Plate 08-002216

1 MS21071L08 Nut Plate 08-001935

9 MS21075L3 Nut Plate 05-004764

2 MS24677-12 Screw 05-011931

6 MS27039-1-09 Screw 07-014232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



AS

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



AS

Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

VR Door shipped Fri MAR 21/08

Harness shipped Thri. MAR 27/08

Date: Monday, 7/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(1)

Comment: FINAL INSPECTION/W/O RELEASE

108/03/07

Job Completion



Work Order Number: 44443 V/door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1**Discrepancy:**

Modify Door to Vertical Reference Door

Resolution:

Modified Door P/N:204-030-853-125 to Vertical Reference Door
as per STC. No. SH92-55 on service order 08-000514.3.
Door assembled as required.

1.1 Work Done By: Richard Semeniuk**The maintenance described above has been performed in accordance with the applicable standards of airworthiness.****AMO 6-81** Signature: Colin Gould on 3/14/2008**Parts:**

Part Number	Description	Lot Number	Condition	Qty
204-030-853-125	L/H DOOR ASSEMBLY	LT-08-000696	Repairable	1
MS21059L08	NUTPLATE	LT-04-029615.2	New	8
MS21059L08	NUTPLATE	LT-04-029615.1	New	2
110-070-41	SEAL	LT-08-002635	New	15
204-030-853-037A	SKIN ASSY	LT-08-001776	New	1
BELL212-L	BUBBLE WINDOW ILO	LT-08-001222	New	1
	EA20469-03 and D412-711-101			
204-030-499-005	ROLLER ASSY	LT-08-003385	New	2

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

Squawk: 1.2**Discrepancy:**

Paint door

Resolution:

Paint door as required

1.2 Work Done By: Colin Gould

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

12

Date: Monday, 2/11/2008 2:14:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR 212/412
 Job Number : 37364
 Estimate Number : 10887
 P.O. Number : Part Number : D412711011
 This Issue : 2/11/2008 S.O. No. : Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : N/A
 Previous Run : 36195 Material :
 Written By : Due Date : 3/21/2008 Qty: 1 Um: Each
 Checked & Approved By : 080211
 Comment : Est Rev: A 04.09.29 New issue KJJLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5673 to Eagle Copters

C. Log 10/2/12

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0 D412711041 Vertical Ref. Door Assy



704443

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0 D412711101 Replacement Bubble Window



LT 08-00122Z

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0 D412711111 Wiring Harness, 212/412



Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

will shipped Separately @ later date

✱

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt 07-18790

22 AN3-4A Bolt 08-001209

24 AN3-7A Bolt 07-017476

6 AN960-6L Washer 05-022623

90 AN960-10L Washer 06-018522

34 CR3242-4-2 Rivet 08-001645

135MS20426AD3-3 Rivet 07-006985

140MS20426AD4-3 Rivet 05-002460

25 MS20470AD3-3 Rivet 07-007189

90 MS20470AD4-3 Rivet 07-005056

24 MS21042L3 Nut 08-002039

2 MS21042L06 Nut 06-014775

13 MS21069L3 Nut Plate 08-001202

8 MS21069L08 Nut Plate 07-018940

1 MS21071L3 Nut Plate 08-002216

1 MS21071L08 Nut Plate 08-001935

9 MS21075L3 Nut Plate 05-004764

2 MS24677-12 Screw 05-011931

6 MS27039-1-09 Screw 07-014232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



AB

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

VRDoor shipped Fri MAR 21/08
Harness shipped

12

Date: Monday, 2/11/2008 2:14:47 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL REFERENCE DOOR 212/412
Job Number : 37364	
Estimate Number : 10887	
P.O. Number :	Part Number : D412711011
This Issue : 2/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : PURCHASED PARTS	Drawing Revision : N/A
Previous Run : 36195	Material :
Written By :	Due Date : 3/21/2008 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev: A 04.09.29 New Issue KJ/JLM	

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 5673 to Eagle Copters

C. 208/02/12 ①

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0	D412711041	Vertical Ref. Door Assy
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764443



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Vertical Ref. Door Assy

4.0	D412711101	Replacement Bubble Window
-----	------------	---------------------------



LT 08-00122Z



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

5.0	D412711111	Wiring Harness, 212/412
-----	------------	-------------------------



Comment: Qty.: 1.0000 Eagle(s)/Unit Total: 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D412-711-111 Wiring Harness, 212/412

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt 07-18796

22 AN3-4A Bolt 08-001209

24 AN3-7A Bolt 07-017476

6 AN960-6L Washer 05-022623

90 AN960-10L Washer 06-018522

34 CR3242-4-2 Rivet 08-001645

135MS20426AD3-3 Rivet 07-006985

140MS20426AD4-3 Rivet 05-002460

25 MS20470AD3-3 Rivet 07-007189

90 MS20470AD4-3 Rivet 07-005056

24 MS21042L3 Nut 08-002039

2 MS21042L06 Nut 06-014775

13 MS21069L3 Nut Plate 08-001202

8 MS21069L08 Nut Plate 07-018940

1 MS21071L3 Nut Plate 08-002216

1 MS21071L08 Nut Plate 08-001935

9 MS21075L3 Nut Plate 05-004764

2 MS24677-12 Screw 05-011931

6 MS27039-1-09 Screw 07-014232

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QCS

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.03.24

Eagle Copters Maintenance Ltd

WORK REPORT

Work Order Number: 44443

V/door

This Work Report forms part of this aircraft's permanent technical records - DO NOT DESTROY.

Item: 1 L/H DOOR ASSEMBLY

Squawk: 1.1

Discrepancy:

Modify Door to Vertical Reference Door

Resolution:

Modified Door P/N:204-030-853-125 to Vertical Reference Door as per STC. No. SH92-55 on service order 08-000514.3.

Door assembled as required.

1.1 Work Done By: Richard Semeniuk

The maintenance described above has been performed in accordance with the applicable standards of airworthiness.

AMO 6-81

Signature: Colin Gould on 3/14/2008

Parts:

Part Number	Description	Lot Number	Condition	Qty
204-030-853-125	L/H DOOR ASSEMBLY	LT-08-000696	Repairable	1
MS21059L08	NUTPLATE	LT-04-029615.2	New	8
MS21059L08	NUTPLATE	LT-04-029615.1	New	2
110-070-41	SEAL	LT-08-002635	New	15
204-030-853-037A	SKIN ASSY	LT-08-001776	New	1
BELL212-L	BUBBLE WINDOW ILO	LT-08-001222	New	1
	EA20469-03 and			
	D412-711-101			
204-030-499-005	ROLLER ASSY	LT-08-003385	New	2

Outside Services:

Qty	Part Number	Serial Number	Part Description	Service Description
1	204-030-853-125		L/H DOOR ASSEMBLY	Modify

Squawk: 1.2

Discrepancy:

Paint door

Resolution:

Paint door as required

1.2 Work Done By: Colin Gould

* End of Report *

***** Original Maintenance Releases and Independent Control Inspection details are stored electronically at *****
***** Eagle Copters Maintenance Ltd. in Calgary Alberta in the Corridor Software *****

L Lacelle

From: Harvey Siemens [hsiemens@dartaero.com]
Sent: March 24, 2008 9:24 AM
To: 'L Lacelle'
Subject: RE: vrd for Edwards
Attachments: WO37364.pdf

Good Morning Linda

Yes, the door did leave on Friday. Please find attached the work order as completed as it is. I am still waiting for the harness (which is supposed to be done on Tuesday), that's why the WO is not complete yet.

If you have any questions just give me a call.

Regards,

Harvey Siemens

Dart Aerospace Ltd
Calgary, Alberta
1-403-717-0328
hsiemens@dartaero.com

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: March 24, 2008 7:06 AM
To: Harvey Siemens
Subject: vrd for edwards
Importance: High

Hi Harvey,
Did Mike M, ship the Edwards door on Friday? I will need the filled out w/o asap.

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

24/03/2008

Date: Monday, 2/11/2008 2:14:47 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR 212/412
 Job Number : 37364
 Estimate Number : 10887
 P.O. Number :
 This Issue : 2/11/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D412711011
 First Issue : / / Type : PURCHASED PARTS Drawing Number : N/A
 Previous Run : 36195 Drawing Revision : N/A
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 04.09.29 New issue KJ/JLM Material :
 Due Date : 3/21/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D412-711-011 CHG001

2.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5673 to Eagle Copters

C268/02/12

①

"Assembly of D412-711-011 Door

Send a copy of this IPP

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Vertical Ref. Door Assy

4.0 D41271101 Replacement Bubble Windo



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

5.0 D412711111 Wiring Harness, 212/412



Comment: Qty.: 1.0000 Eagle(s)/Unit Total : 1.0000 Eagle(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D412-711-111 Wiring Harness, 212/412

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

EA2046915412

Instrument Panel, 412



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 EA20469-15-412 Instrument Panel, 212/412

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window

1 EA20469-05 Rubber Strip

1 EA20469-06 Aluminum Strip

1 EA20469-07 Angle

1 EA20469-08 Placard

1 EA20469-10 Rear Rib Assy

1 EA20469-11 Angle

1 EA20469-12 Fwd Rib

1 EA20469-13 Window

1 EA20469-14 Window Retainer

1 EA20469-16 Armrest Assy

1 EA20469-17 Angle

1 EA20469-18 Door Inner Skin

1 EA20469-21 Door Cover Panel

2 EA20469-23 Link

1 EA20469-24 Rod

1 EA20469-25 Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-EAGLE

Pick:

Qty Part Number Description Batch

14 AN3-3A Bolt _____

22 AN3-4A Bolt _____

24 AN3-7A Bolt _____

6 AN960-6L Washer _____

90 AN960-10L Washer _____

34 CR3242-4-2 Rivet _____

135MS20426AD3-3 Rivet _____

140MS20426AD4-3 Rivet _____

25 MS20470AD3-3 Rivet _____

90 MS20470AD4-3 Rivet _____

24 MS21042L3 Nut _____

2 MS21042L06 Nut _____

13 MS21069L3 Nut Plate _____

8 MS21069L08 Nut Plate _____

1 MS21071L3 Nut Plate _____

1 MS21071L08 Nut Plate _____

9 MS21075L3 Nut Plate _____

2 MS24677-12 Screw _____

6 MS27039-1-09 Screw _____

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install
EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:14:48 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR 212/412

Job Number: 37364

Part Number: D412711011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries